

Date: Thursday, 5/4/2006 11:12:59 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD PLATE ASSEMBLY
Job Number : 26947	
Estimate Number : 12222	
P.O. Number : N/A	Part Number : D3467043
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3467 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26602	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 5/28/2006 Qty: 8 Um: Each
Checked & Approved By : <i>06.05.05</i>	
Comment : Est Rev: A New Issue 06-04.24 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34679	FWD PLATE
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-9	Fwd Plate	<i>26984</i>

2.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
6	NAS1031C3W	Nut Plate	<i>M 100049</i>

*SB 06/06/07 (7)*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

*SB 06/06/07 7*

4.0	QC5	WELD INSPECTION
-----	-----	-----------------

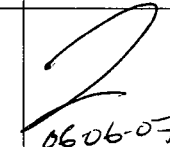



Comment: WELD INSPECTION

*0607*

*(P10)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-07	4	QC 5/11/ Qc11 for spot welds. permanent change					 0606-07

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/08  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:12:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD PLATE ASSEMBLY

Job Number: 26947

Part Number: D3467043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sty38

*104/6/7 (7)*

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/08 (7)*  
*06-06-08*

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

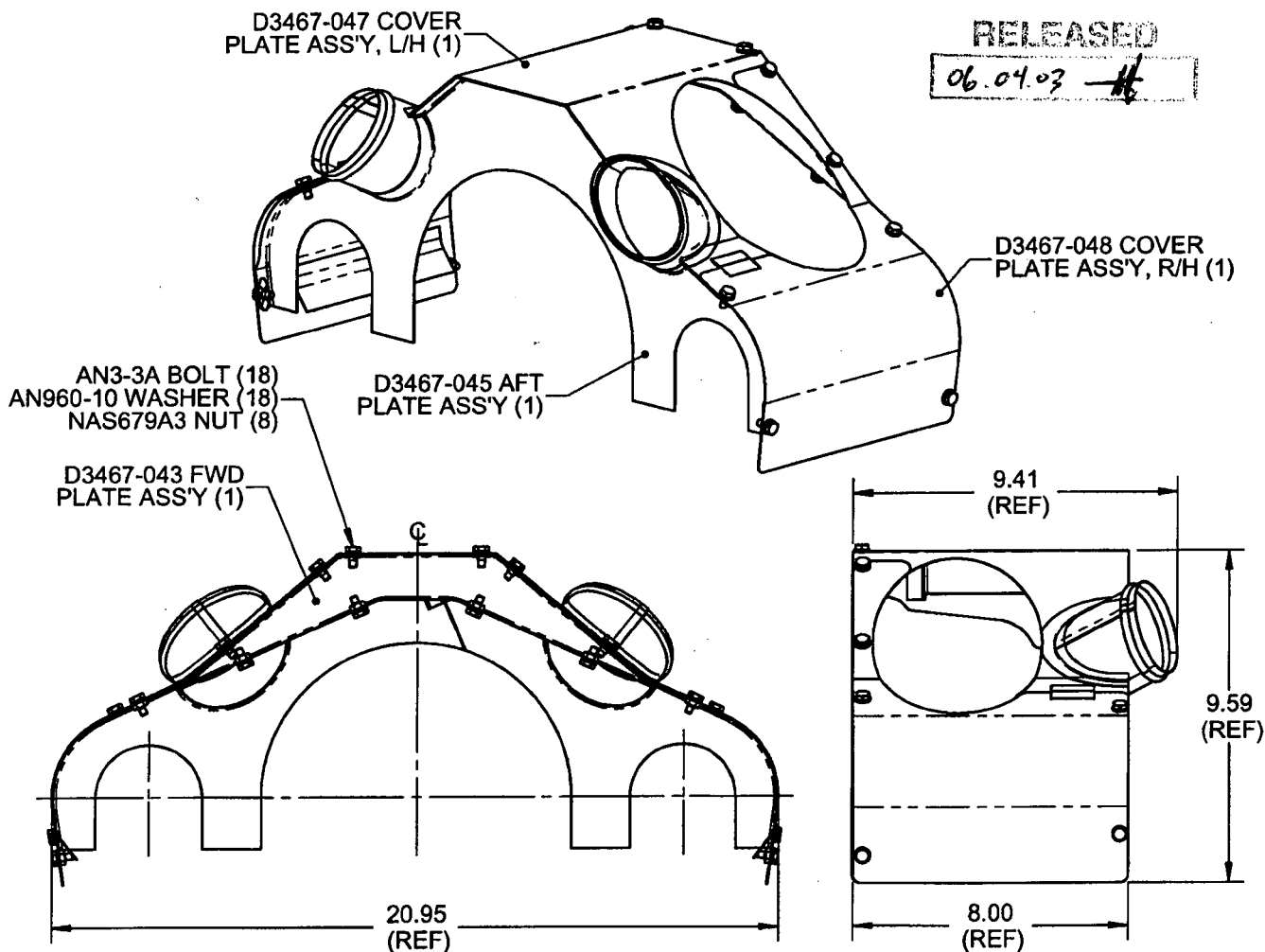
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. A SHEET 1 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

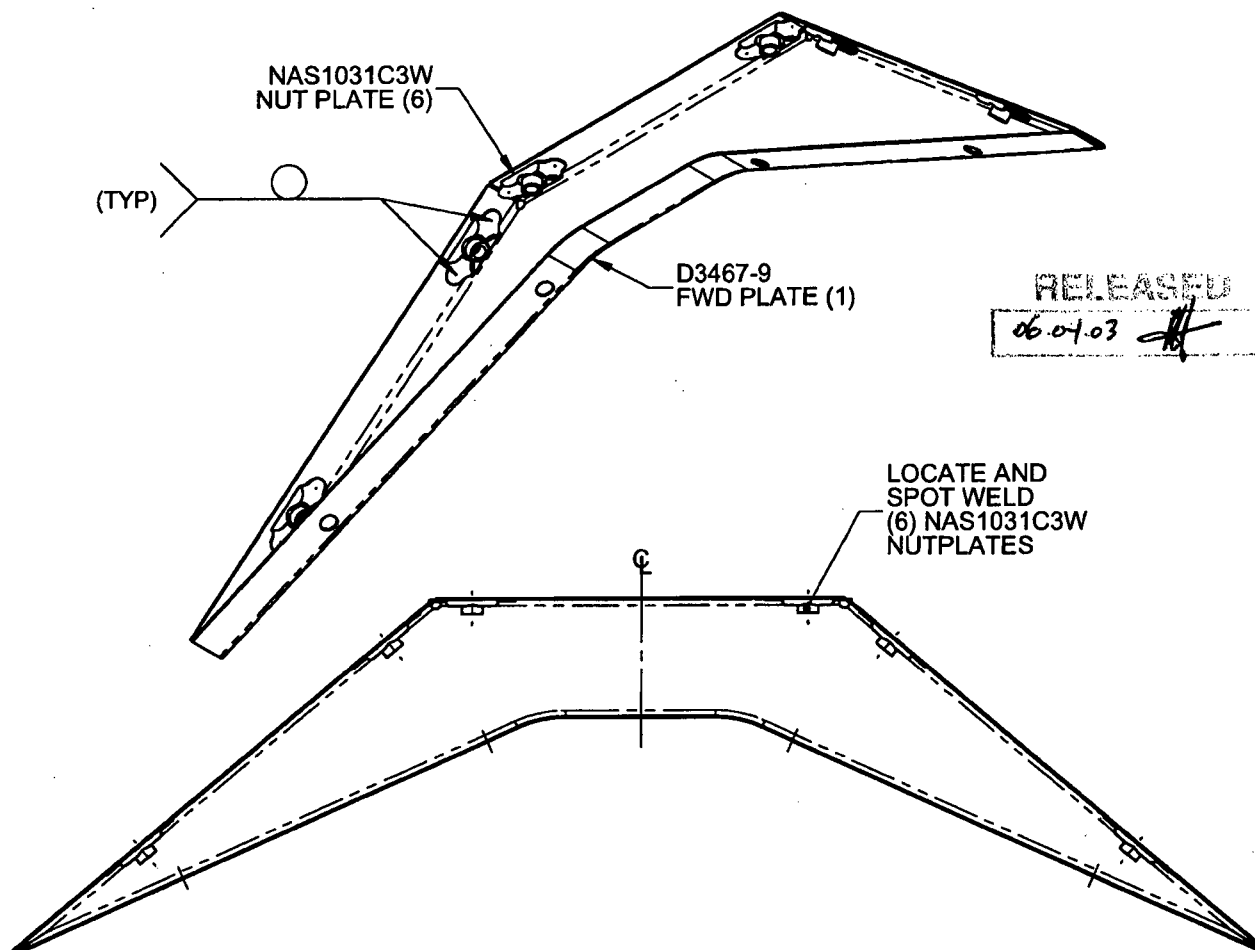
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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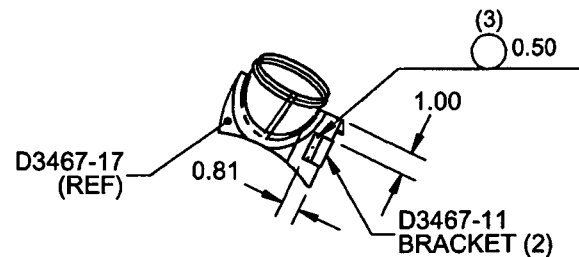
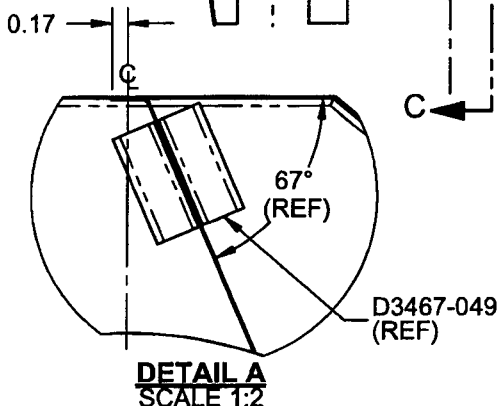
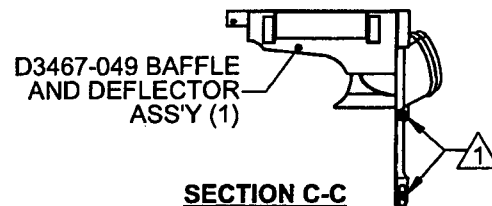
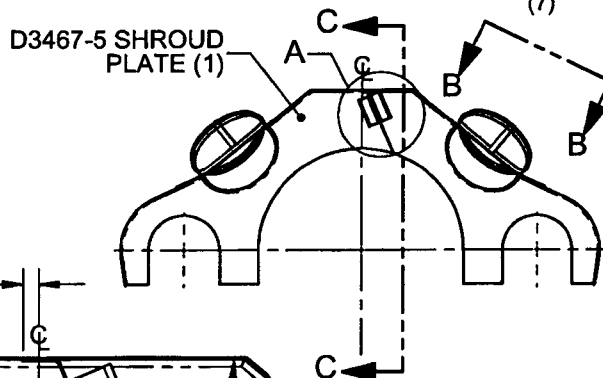
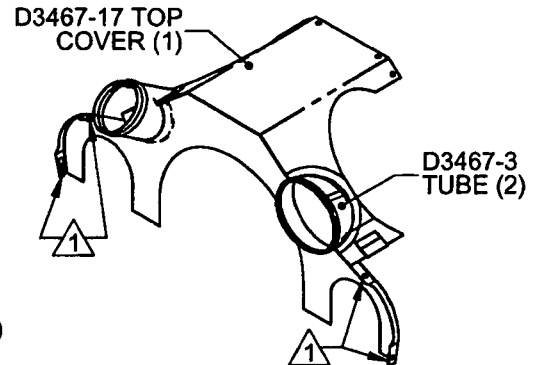
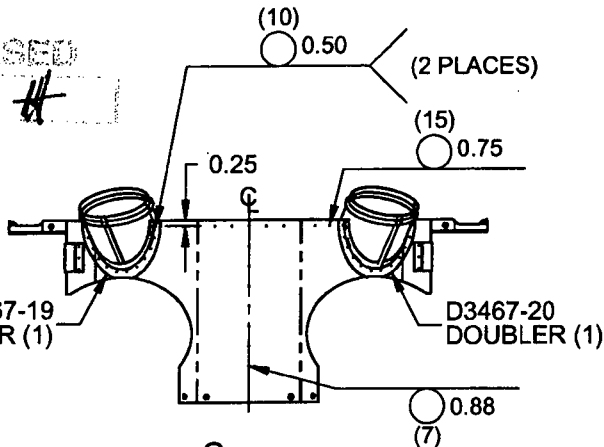
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NO 26947

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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8

RELEASED

06 04.03



**VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)

### D3467-045 AFT PLATE ASSEMBLY

#### NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

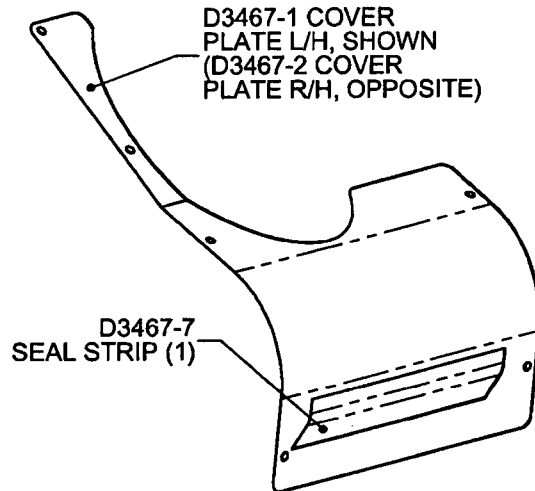
QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE SHOP COPY
1	D3467-5	SHROUD PLATE RETURN TO
2	D3467-11	BRACKET ENGINEERING
1	D3467-17	TOP COVER UNCONTROLLED COPY
1	D3467-19	DOUBLER SUBJECT TO AMENDMENT
1	D3467-20	DOUBLER WITHOUT NOTICE
4	NAS1031C3W	NUT PLATE WORK ORDER NO. 26947

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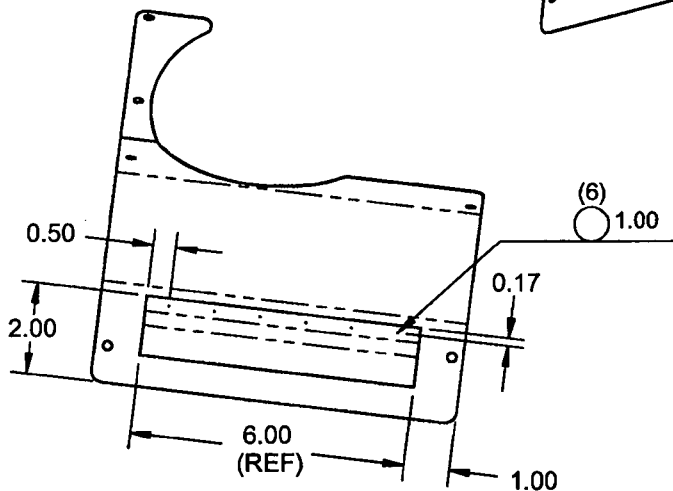
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



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**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

SHOP COPY  
30° TURN TO  
(REF) FERRING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26947

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

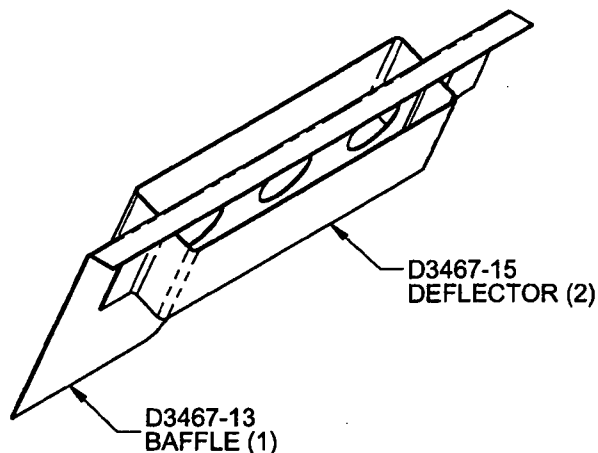
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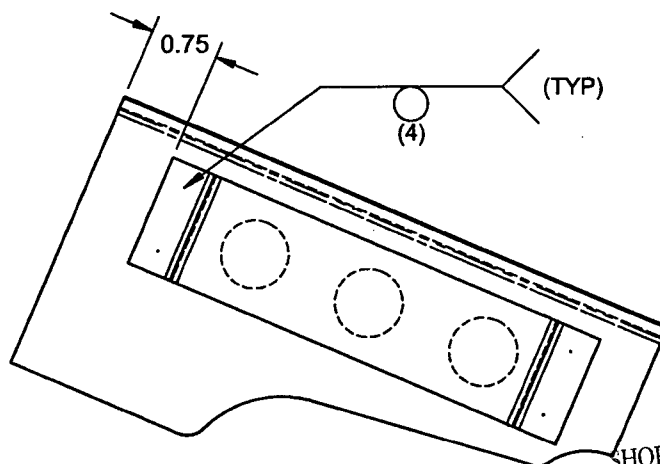
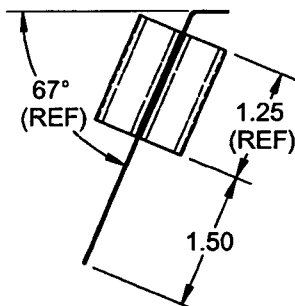




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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



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### D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

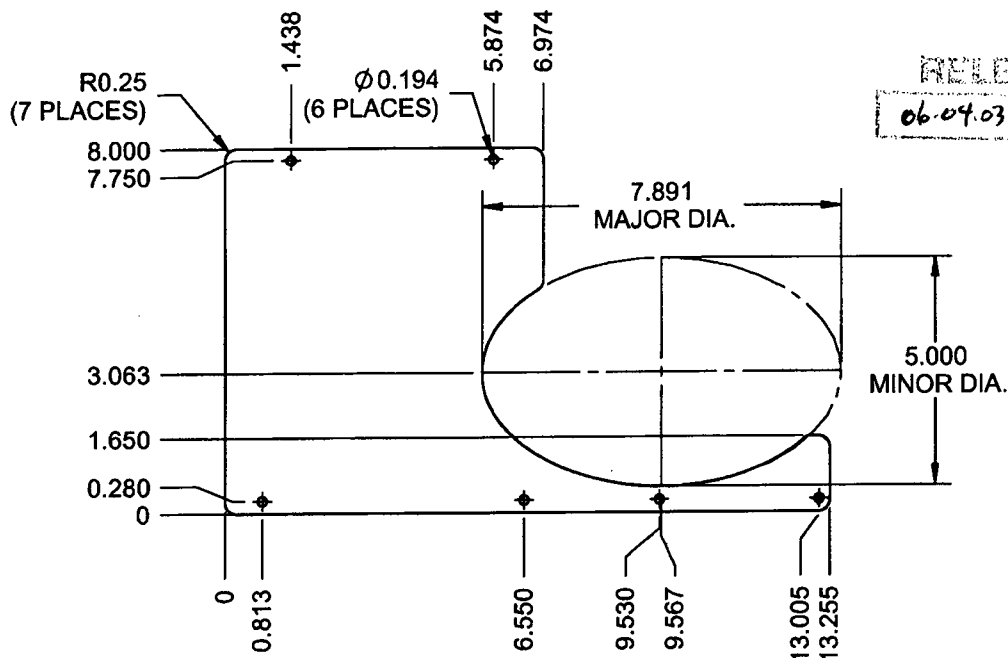
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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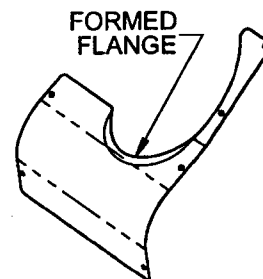
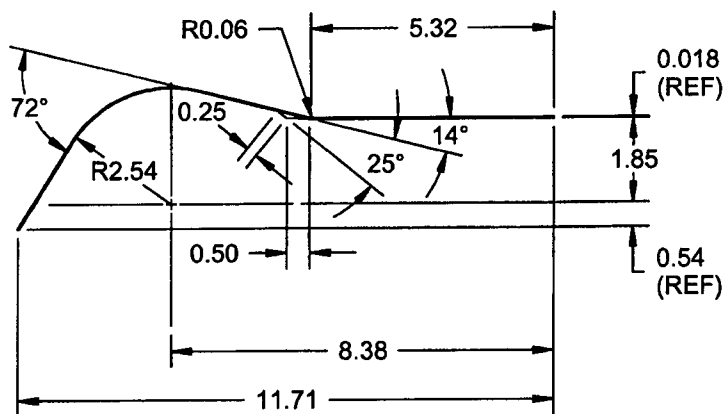


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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4



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### D3467-1F COVER PLATE FLAT PATTERN



### D3467-1 L/H COVER PLATE ISOMETRIC VIEW D3467-2 R/H COVER PLATE (OPPOSITE) SCALE 1:8

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

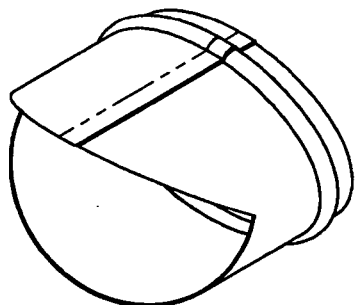
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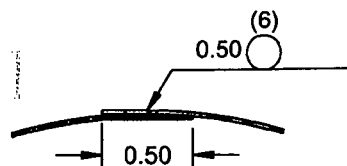
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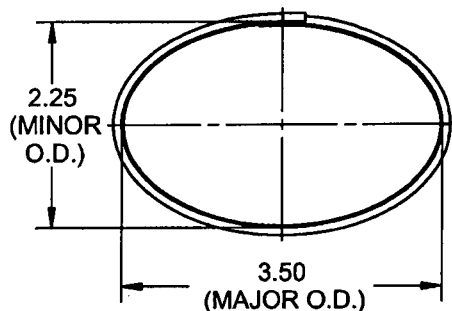
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DATE <b>05.12.07</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:2



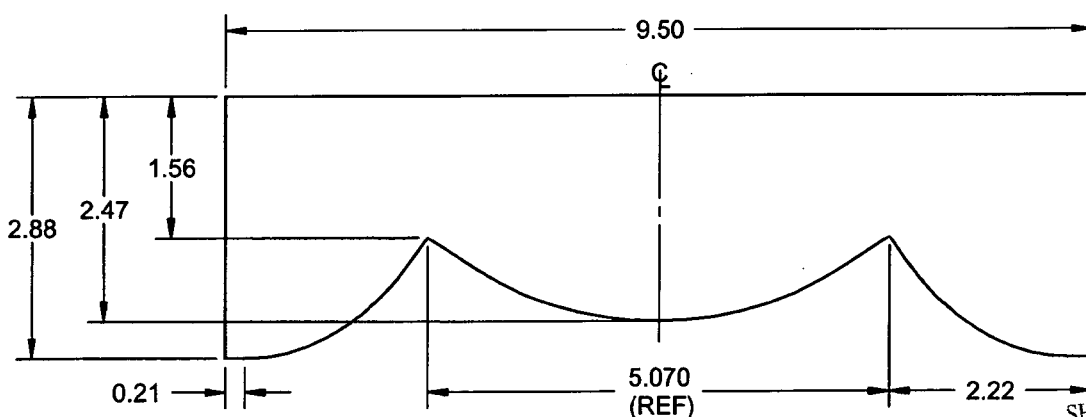
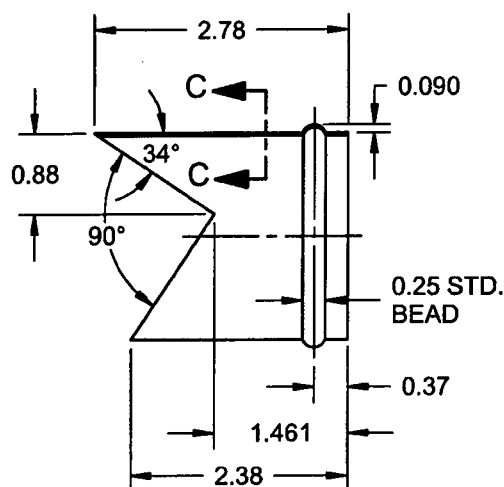
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06.04.03 *H*



**SECTION C-C**  
SCALE 1:1



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

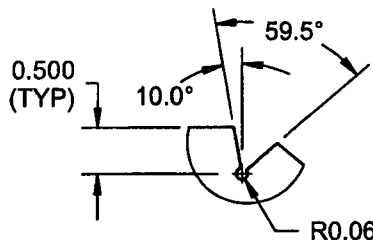
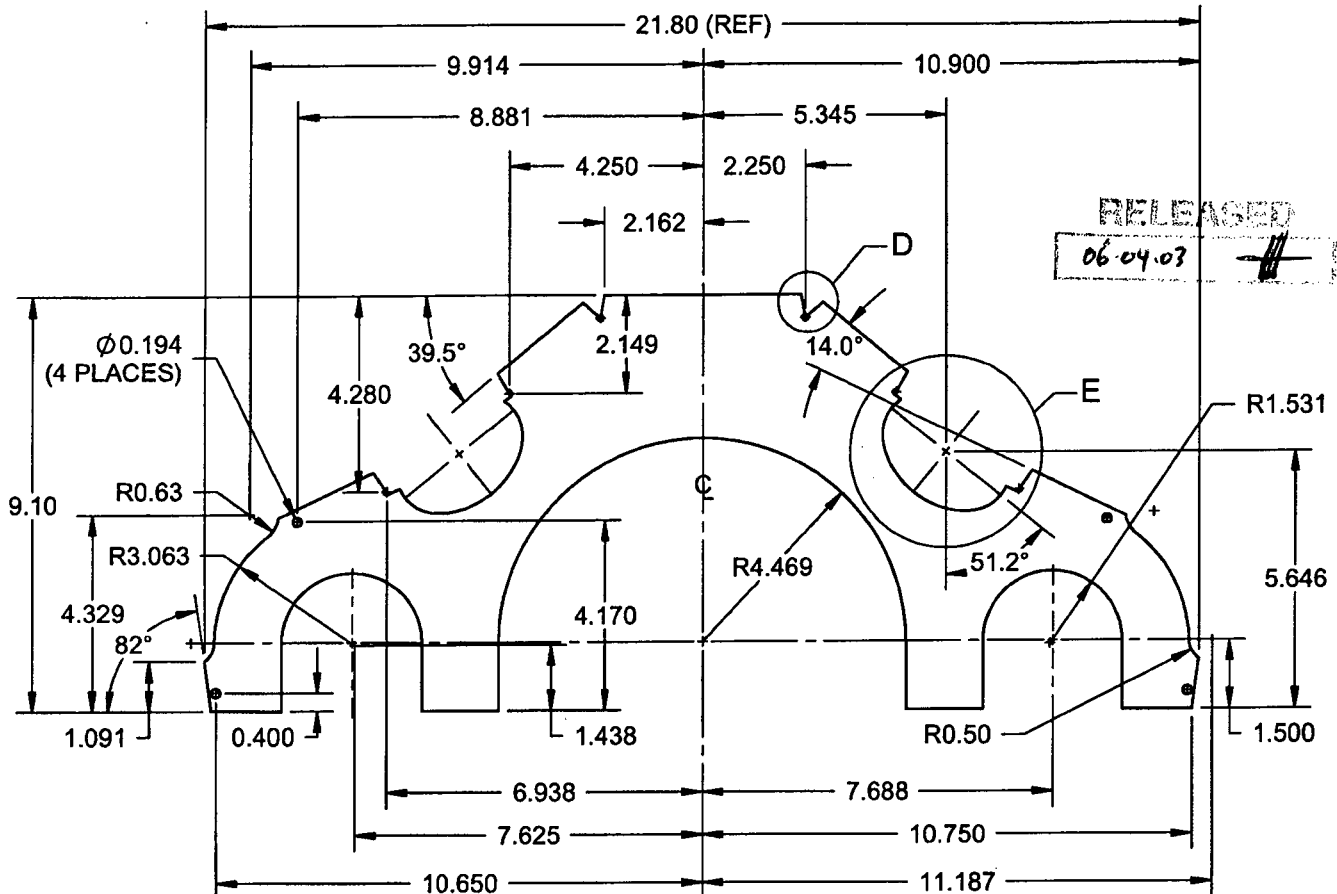
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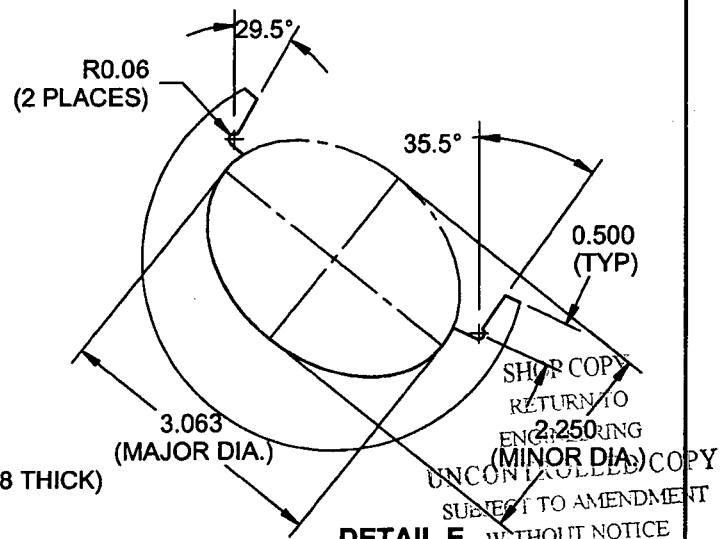
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



**DETAIL D**  
SCALE 1:2



**DETAIL E**  
SCALE 1:2

### **D3467-5F AFT PLATE FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

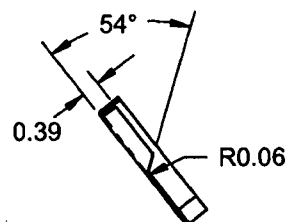
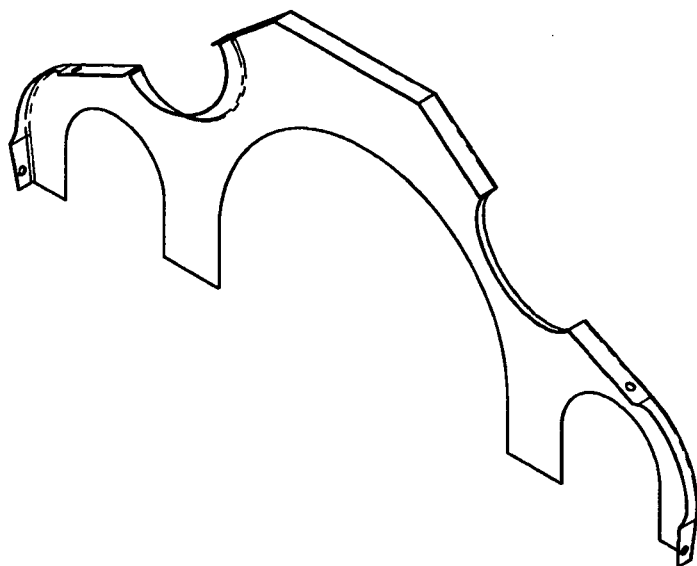
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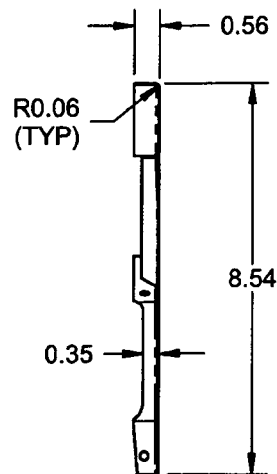
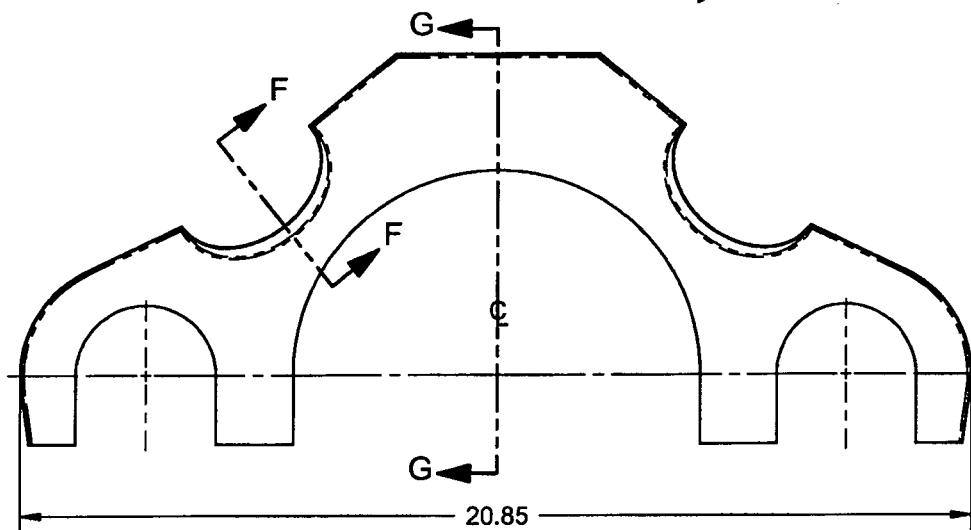
NO. **26947**



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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**SECTION F-F**



**SECTION G-G**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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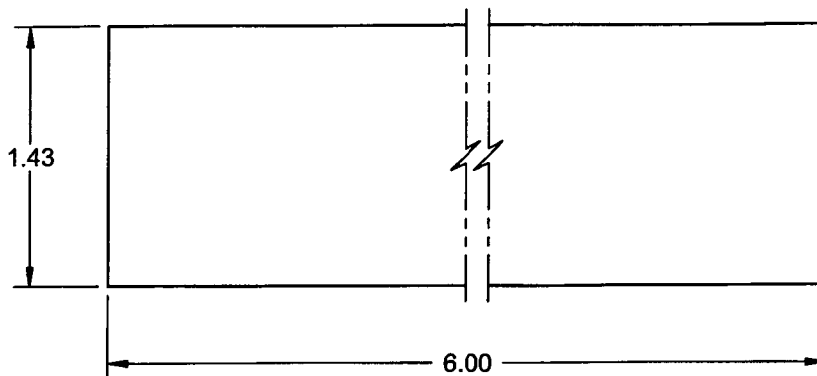
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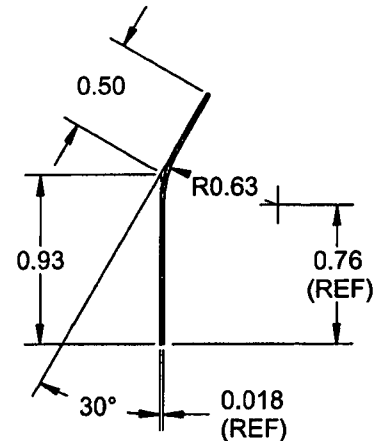
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:1

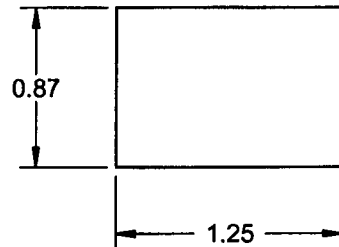
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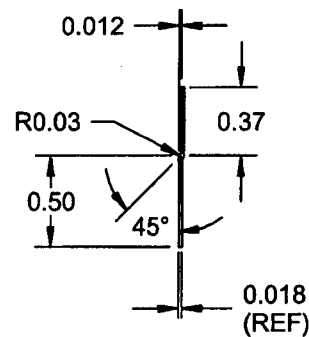
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

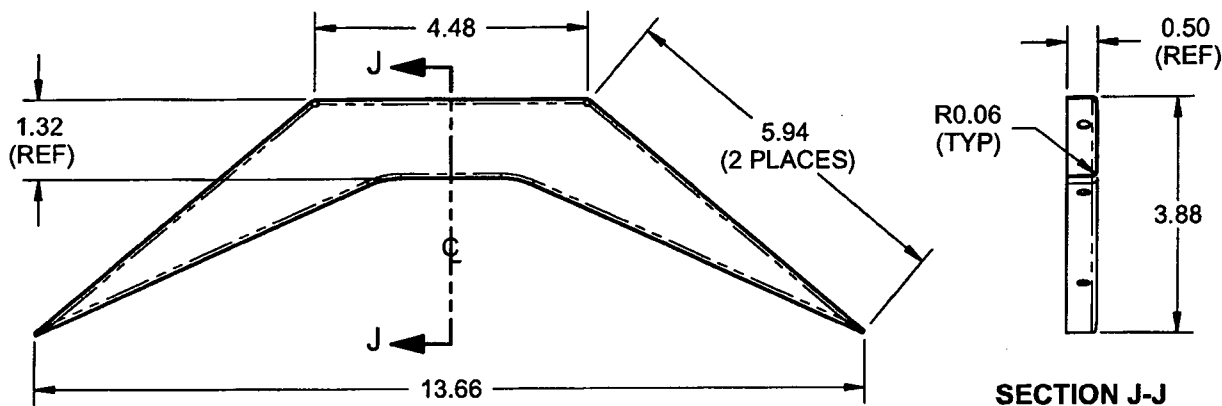
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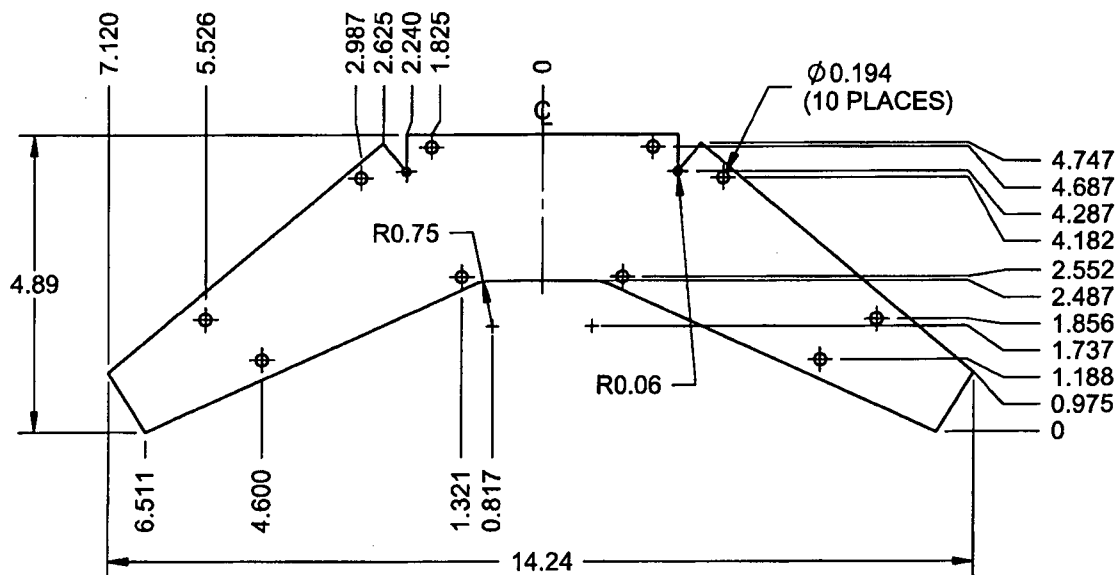
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:3



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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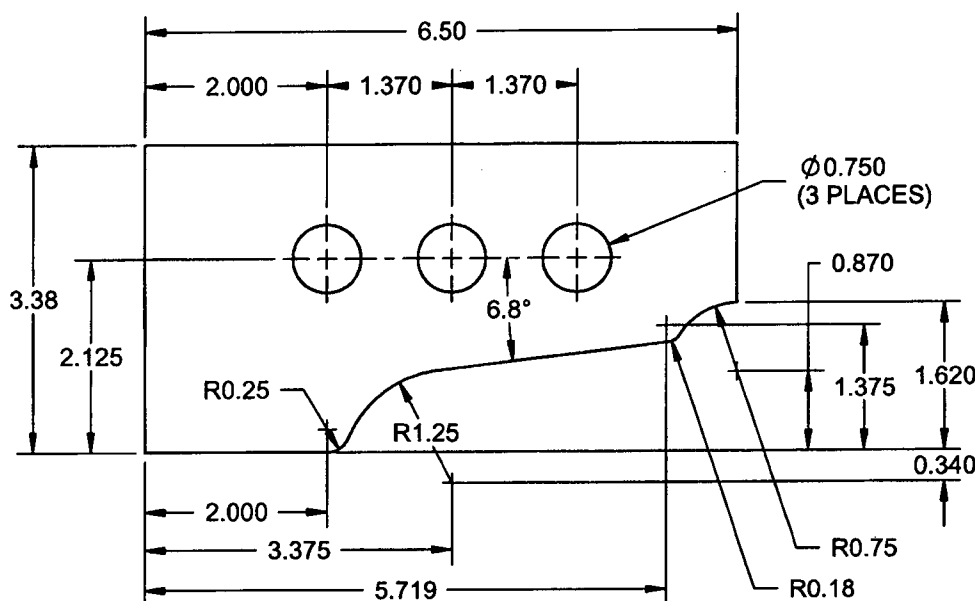
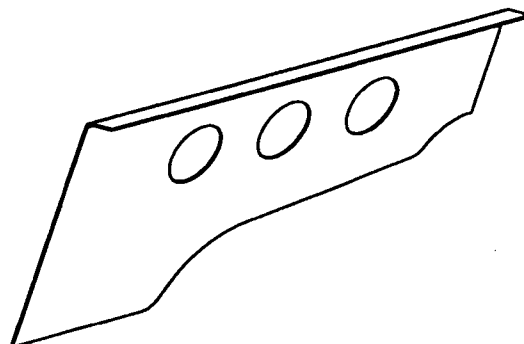
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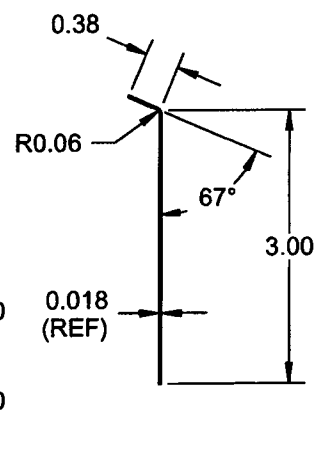


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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2

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**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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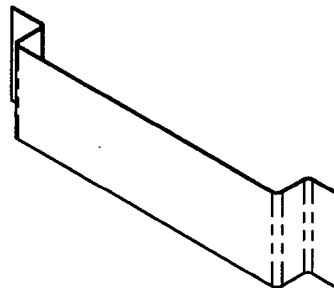
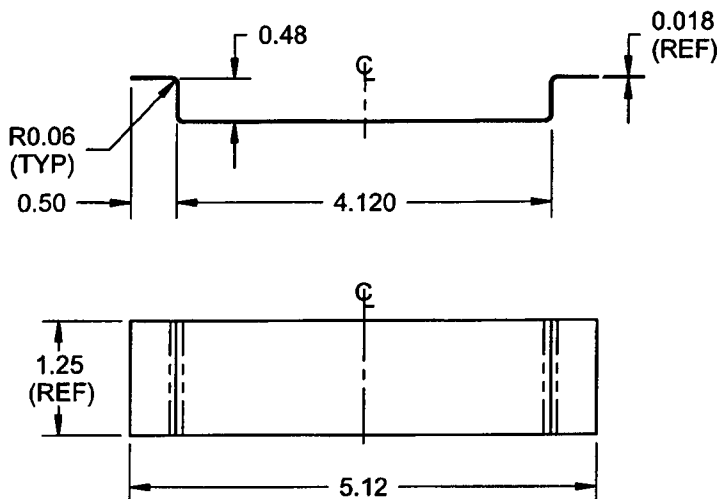
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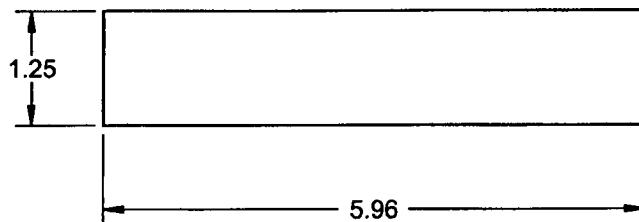


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2

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### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

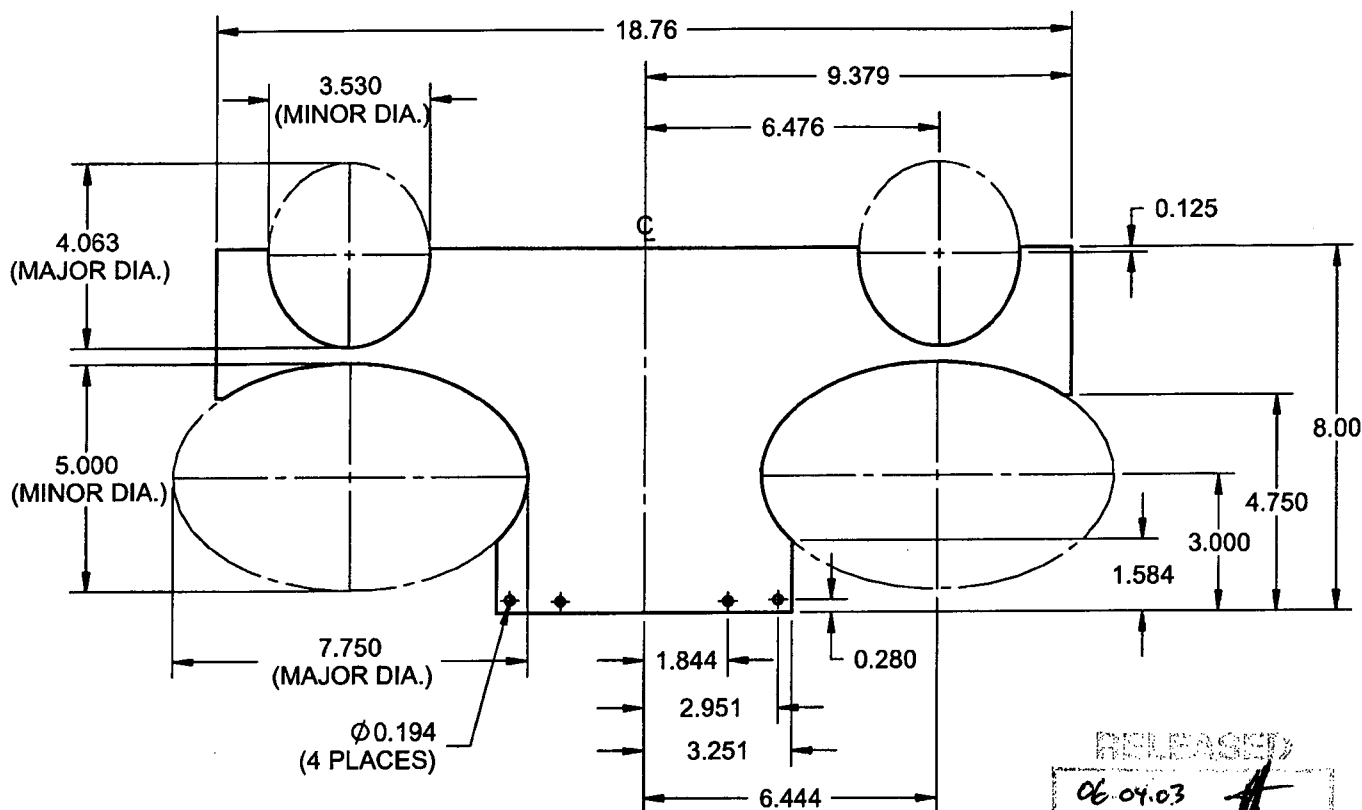
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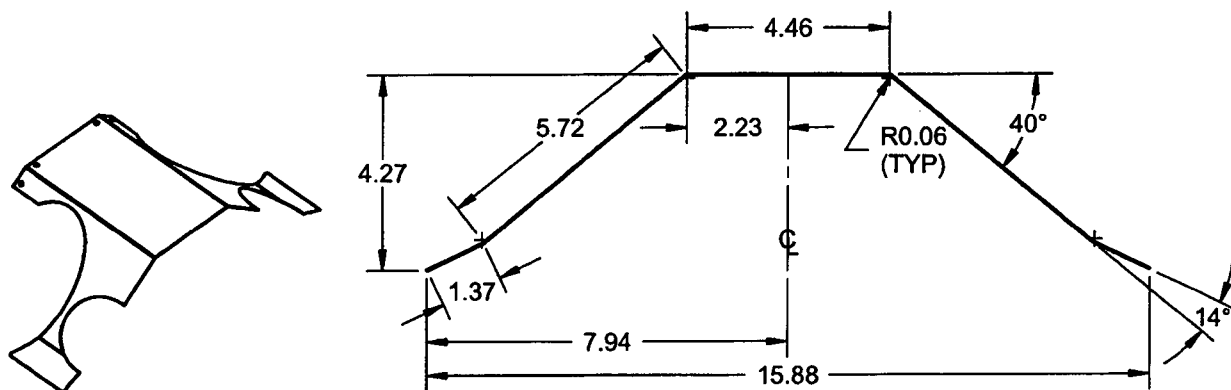
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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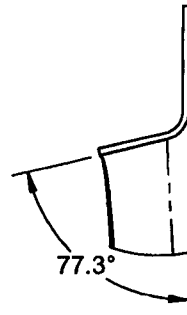
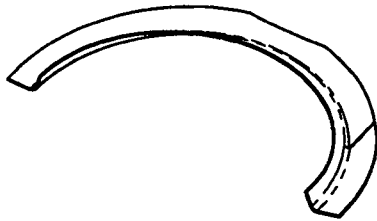
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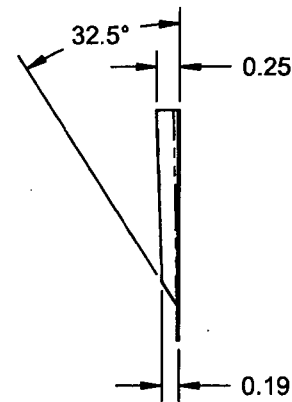
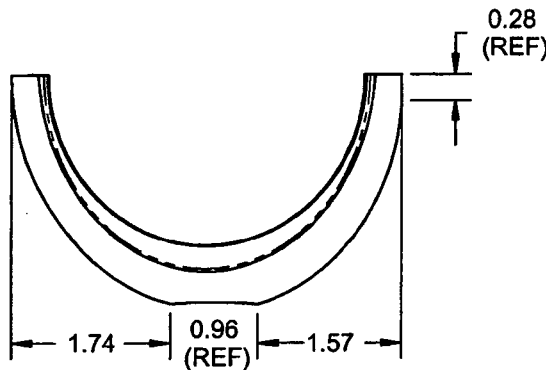
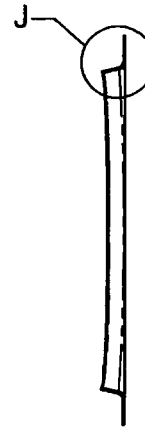
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

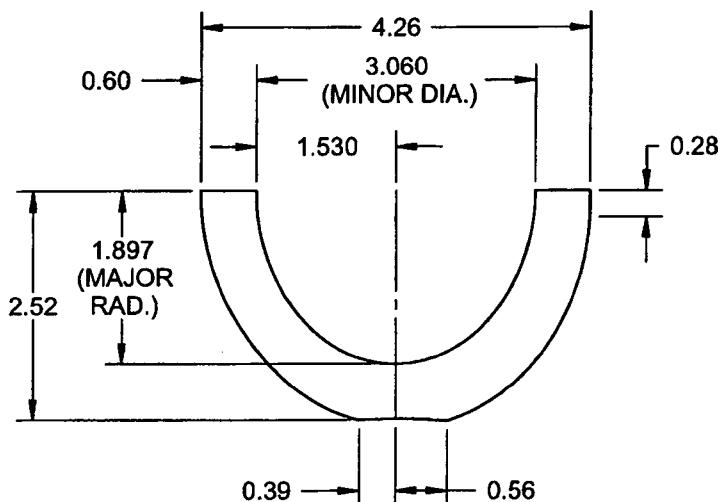
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**DETAIL J**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



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**D3467-19F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dale Trepanier**

---

**From:** Dale Trepanier [dtrepanier@dartaero.com]

**Sent:** Thursday, June 08, 2006 10:29 AM

**To:** Jean-Luc Menard

**Subject:** inspection level 11

Could you please revise D3467-043 step 4 to have QC5/11 for the spot weld?

Thanks,

*Dale Trepanier*

dtrepanier@dartaero.com

Quality Assurance Coordinator